

Date: Tuesday, 3/14/2006 10:04:28 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ANGLE
<b>Job Number</b> : 26231	
<b>Estimate Number</b> : 11459	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D314085
<b>This Issue</b> : 3/14/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3140 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 25895	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 3/21/2006
<b>Checked &amp; Approved By</b> : SEE ABOVE USER & DATE	<b>Qty:</b> 3 <b>Um:</b> Each
<b>Comment</b> : Est. A 02.04.30 New Issue NG	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M5052H32S040	5052-H32 .040 Sheet
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**Comment:** Qty.: 0.3688 sf(s)/Unit Total : 0.3688 sf(s)  
 M5052H32S.040 SHEET  
 Batch M15982

SB 06/03/14

②

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Cut as per dwg D3140 26.65" long  
 Deburr.  
 No sharp edges  
 Contour as per dwg

B/SB 06/03/14

②

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

26-03-14 06-03-14

2

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

18 06-03-15

2

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/03/15

④

Qty 2 of B25895

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 06/03/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 3/14/2006 10:04:28 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 26231

Part Number: D314085

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W 06-03-15

06/03/15

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Doubler Assembly		<b>Part Number:</b>	<b>D3140-10</b>
<b>Dwg:</b> D3140 Rev. B Pages 5,6		<b>Qty:</b>	
D3140-10 replaces Premier P/N B30-23000-10		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																
1	DC	Issue Traveller <b>Note: D3140-10 to be made in multiples of 10.</b>																			
2	MV	Cut blanks: 6.000" x 43.000" (+0.010/-0.000) Material: 2024-T3 (QQ-A-250/4) 0.032" thick (M2024T3S.032) <b>Identify as D3140-89</b> Batch: _____																			
3	MV	Cut blanks: 26.65" x 1.90" Material: 5052-H32/H34 (QQ-A-250/8) 0.040" thick (M5052H32S.040) <b>Identify as D3140-85</b> Batch: _____																			
4	MV	Machine D3140-89 as per Folio FA226 and Dwg D3140 <b>Stack of 10</b>																			
5	QC2	Inspect parts as they come off the CNC machine																			
6	MV	Deburr <b>Identify as D3140-89</b>																			
7	QC8	Second inspection																			
8	GA	Take material for D3140-85 and Bend as per Dwg D3140																			
9	GA	Form as per Jig D3140-301T1 and Dwg D3140 and Deburr <b>Identify as D3140-85</b>																			
10	QC5	Inspect work to Step 9																			
11	FP	Pick D3140-89 and D3140-85 for Chemical Conversion Coat per QSI 005 4.1																			
12	QC3	Inspect Conversion Coat																			
13	GA	Place D3140-85 Angle onto D3140-89 Doubler as per Dwg D3140. <b>**Note: D3140-10 is as shown**</b> Transfer drill from D3140-89 Doubler into D3140-85 Angle. Hole size is 0.098" (#40). Re-alodine holes. Assemble as per Dwg D3140 <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3140-85</td><td>Angle</td><td>02622/125815</td></tr><tr><td>1</td><td>D3140-89</td><td>Doubler</td><td>25732</td></tr><tr><td>5</td><td>MS20426AD3-4</td><td>Rivet</td><td>415706</td></tr></table>	Qty	Part Number	Description	Batch	1	D3140-85	Angle	02622/125815	1	D3140-89	Doubler	25732	5	MS20426AD3-4	Rivet	415706			
Qty	Part Number	Description	Batch																		
1	D3140-85	Angle	02622/125815																		
1	D3140-89	Doubler	25732																		
5	MS20426AD3-4	Rivet	415706																		
14	QC5	Inspect 100% Kit for Completeness on the W/O																			
15	ST	Identify and Stock																			
16	AC	Cost / part																			
17	DC	Close W/O Inspect Level 21																			

Rev	Date	Change	Revised By	Approved
A	02.05.07	New issue	NG	
B	03.01.29	Incorporated material D3140-89/-85	KJ/RF	